

Work Order ID 79206

79206

Page 1

January-23-12 2:00:03 PM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS I
 HAAS CNC vertical machine #1
 Memo
 Program part number and batch number.
 Inspect part number and batch number are programmed
 MACHINE AS PER FOLIO FB068 & DWG
 DWG REV: E
 FOLIO REV: 99
 10 0

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv
 Conventional Milling Machine
 Memo
 Machine Keyway and inspect per attached dimension sheet
 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79206***79206***

Page 2

January-23-12 2:00:04 PM

Item ID: D2662-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 23/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

B.A 12/02/17

10

φ

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

SL 12-02-18

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10X φ M/L 12/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVENTEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				10	12221		
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12/2/21	D		
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>435</u> Memo	0.00 0.00				12/2/21			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 79206***79206***

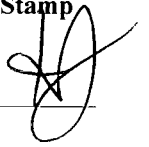
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/2/21 
mf
12-02-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-23-12 2:00:10 PM

Page 1

Work Order ID: 79206

79206

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev:D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured No

100

Each

14.0000

1

10

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

14

69677

2

73774

11

76836

1

78598

1.0

FK 12/02/15

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD				Work Order: 79206	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.127	0.127	0.127	0.127	0.127
G	0.210	0.230		0.227	0.227	0.227	0.227	0.227
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.330	1.330	1.330	1.330	1.330
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.136	1.136	1.136	1.136	1.136
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145.140		0.138	0.138	0.138	0.138	0.138
P	0.240	0.260		0.255	0.255	0.255	0.255	0.255
Q	0.677	0.697		0.687	0.687	0.687	0.687	0.687
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.922	0.922	0.922	0.922	0.922
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.501	0.501	0.500	0.500	0.500
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.122	0.122	0.122	0.122	0.122
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AH								
AI								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79206
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

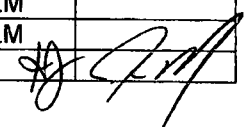
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: DA **Date:** 12/02/17

Audited by: SL **Date:** 12-02-18

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order: 79206
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Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.127	0.127	0.127	0.127	0.127
G	0.210	0.230		0.227	0.227	0.227	0.227	0.227
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.330	1.330	1.330	1.330	1.330
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.136	1.136	1.136	1.136	1.136
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145	NO	0.138	0.138	0.138	0.138	0.138
P	0.240	0.260		0.255	0.255	0.255	0.255	0.255
Q	0.677	0.697		0.687	0.687	0.687	0.687	0.687
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.922	0.922	0.922	0.922	0.922
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.500	0.500	0.500	0.500	0.500
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.122	0.122	0.122	0.122	0.122
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AH								
AI								

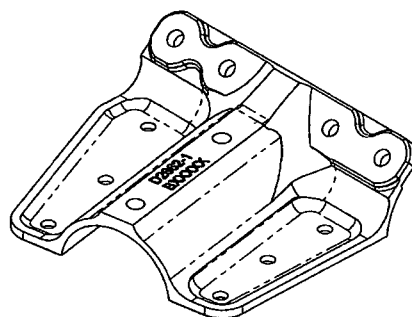
DART AEROSPACE LTD		Work Order:	79206
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

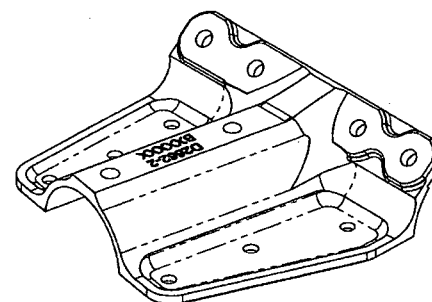
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:	B.A.	Date:	12/02/17
Audited by:	JL	Date:	12-02-18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

ST.
R
E
UNCON
SUB
WIT
V.C

NO 79206 M.C.S
12/01/23

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-035	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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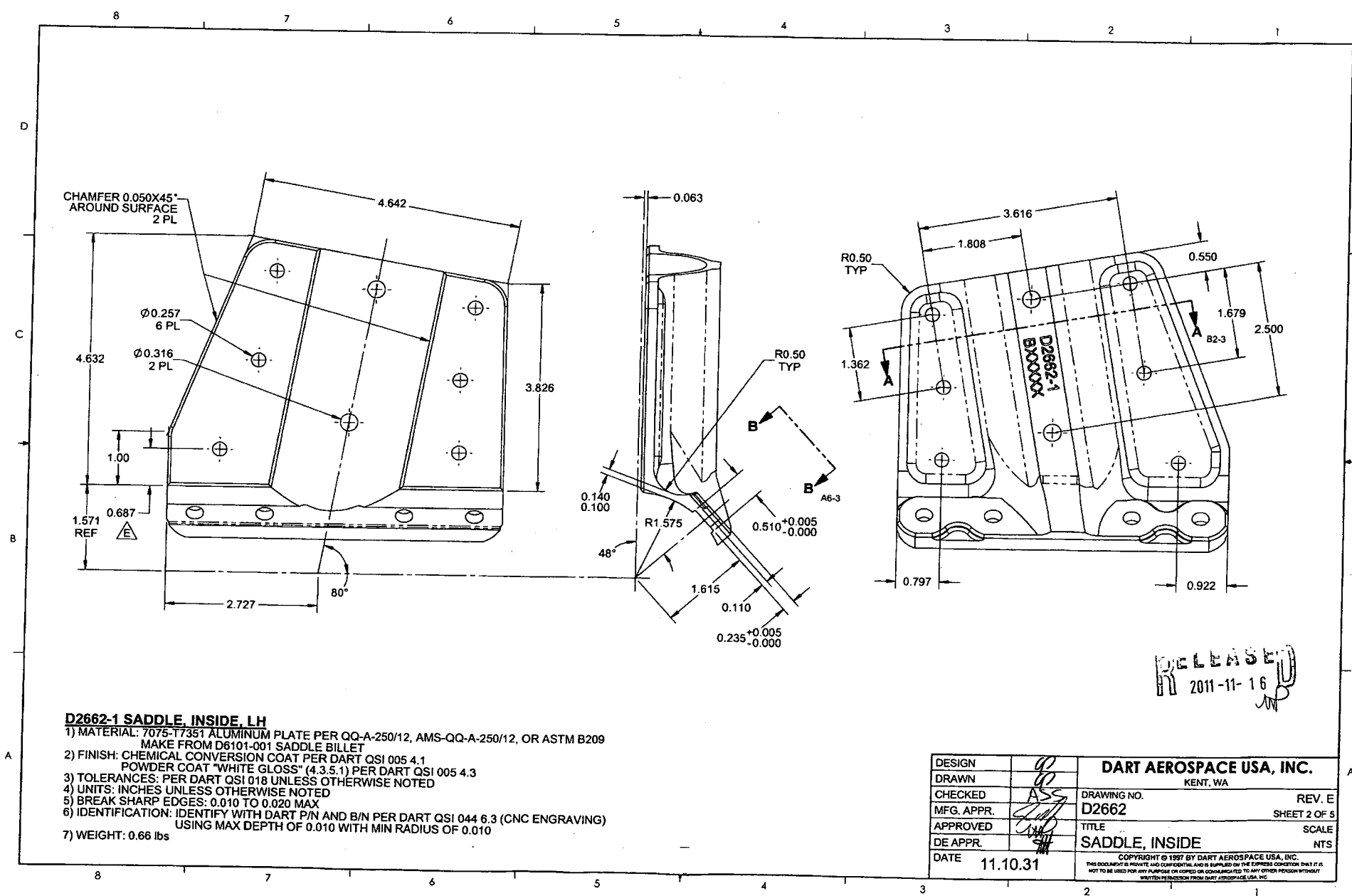
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79206



RELEASED
2011-11-16

D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

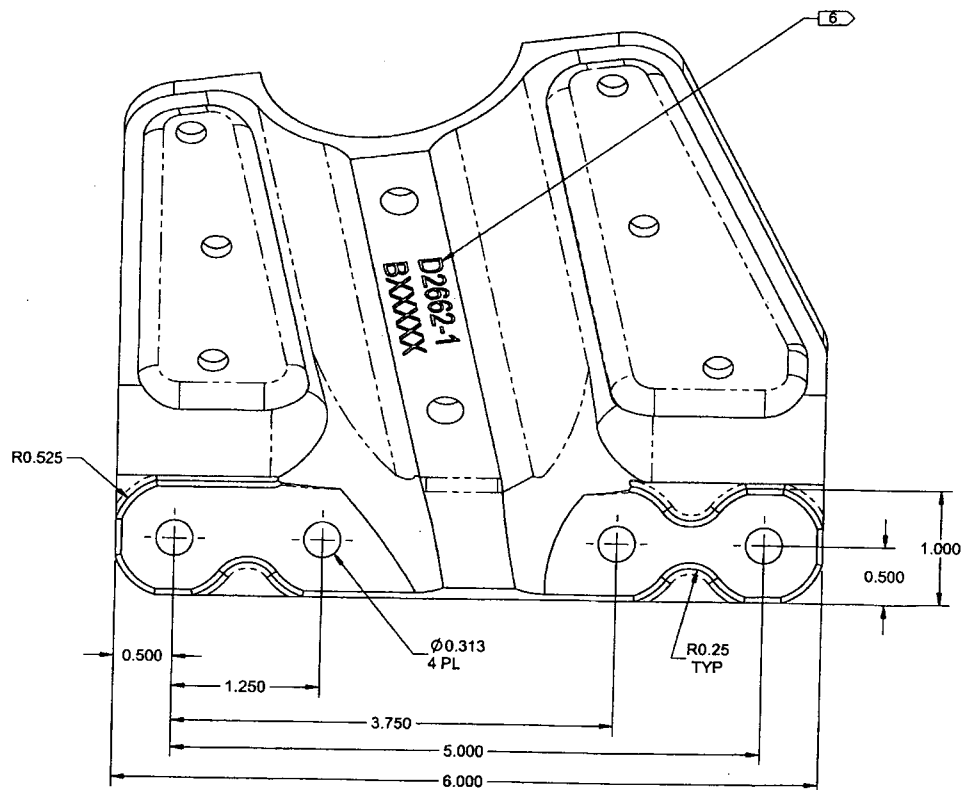
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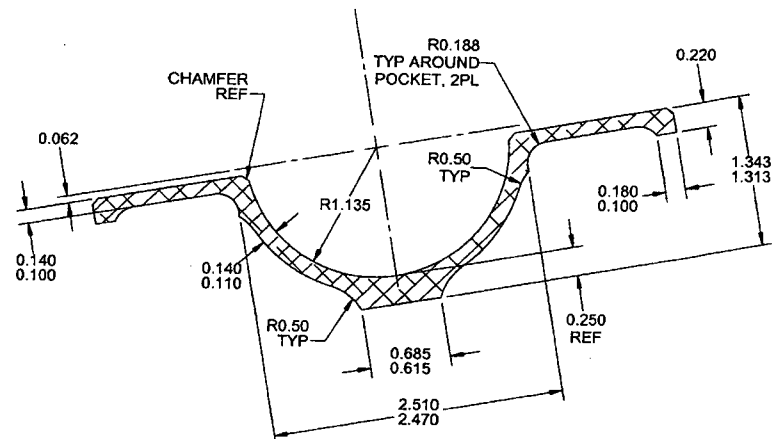
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

79206



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C1-2

RELEASED
2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	SM	D2662	SHEET 3 OF 5
APPROVED	SM	TITLE	SCALE
DE APPR.	SM	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DOPED OR COMPARED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

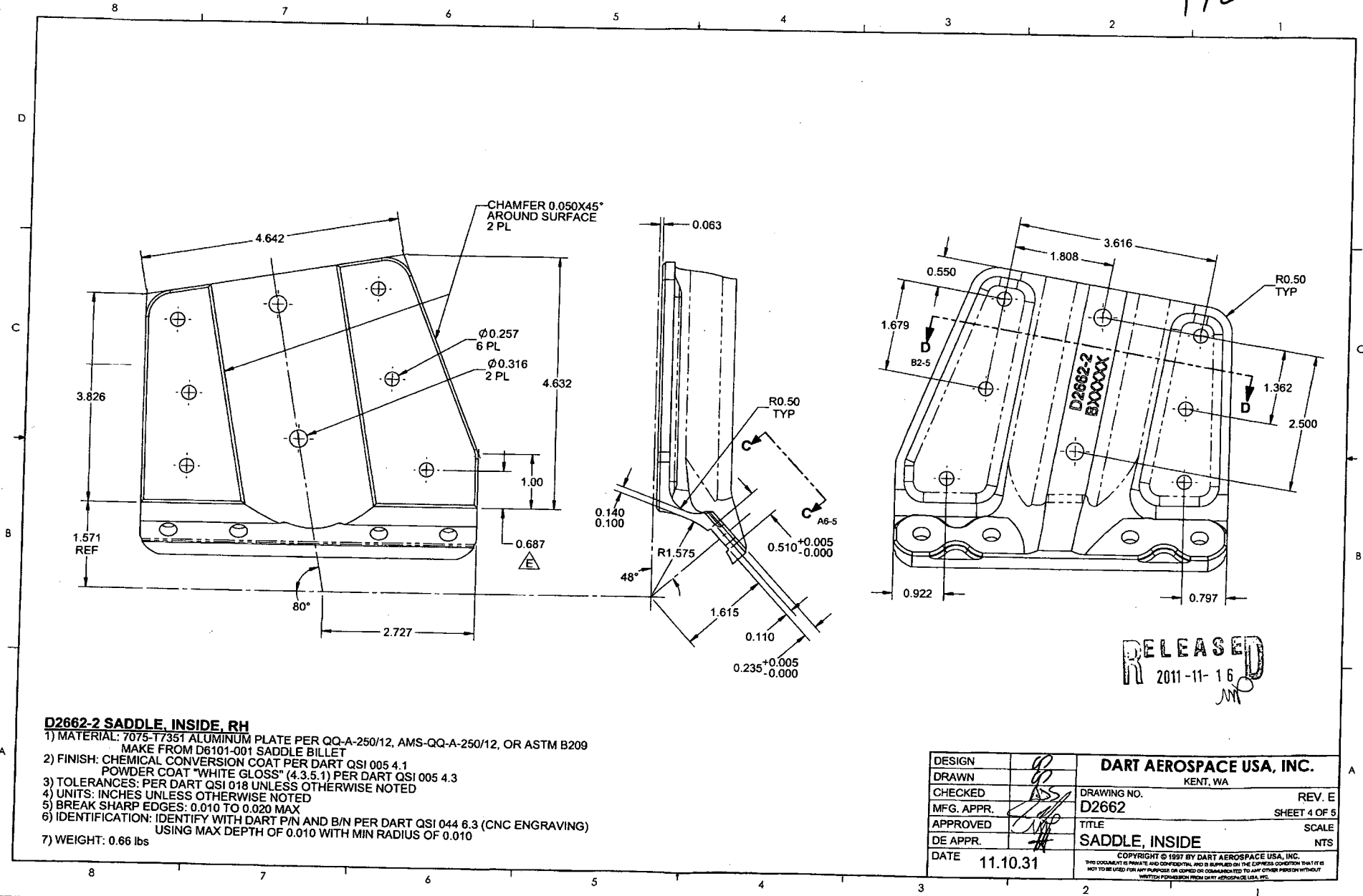
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79206



RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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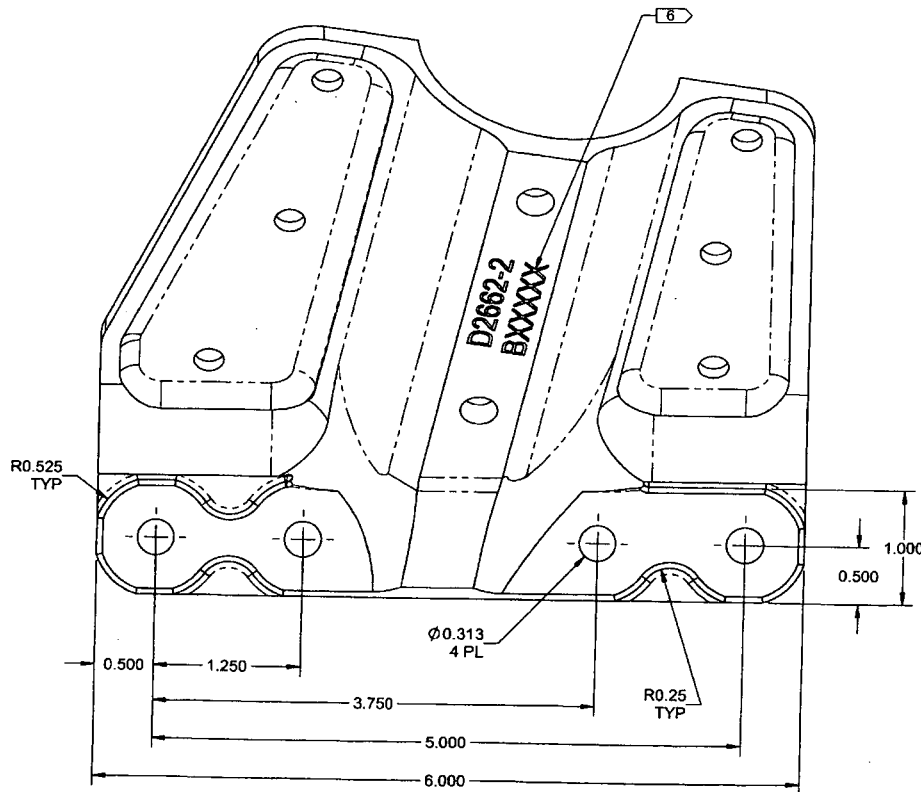
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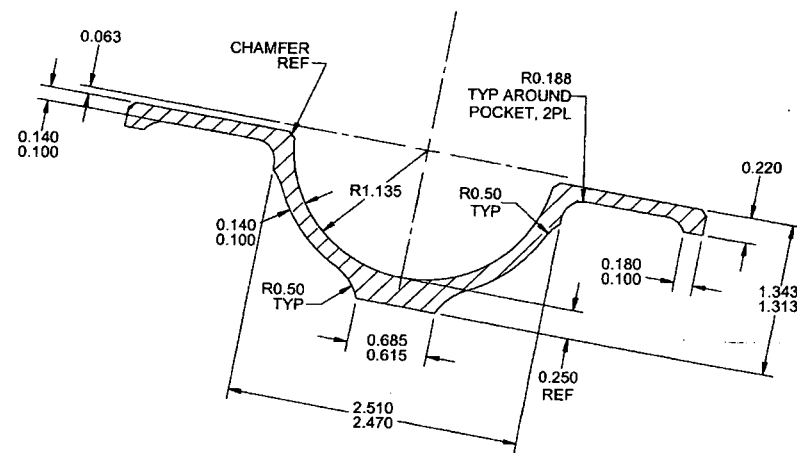
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79206



VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
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